



Dart Aerospace Ltd.
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Tel (613) 632-5200
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646.3511
Job Sheet 186244



Part No: 646.3511

Job Qty: 20 ea

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs	11/28/18	11/28/18	0.00	0.81	Waterjet - Flow		DL 18/11/19
120	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC2 Waterjet-1		DL 18/11/19
130	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC8-1		38
140	Small Fab	20 pcs	11/28/18	11/28/18	0.00	8.40	Small Fab-1		DAS 9-89 EL
150	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC5		43
160	Large Fab	20 pcs	11/28/18	11/28/18	0.00	22.99	Large Fab 1		9-89 EL
170	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC9		9-89 DAS PPL
180	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC5		24
220	SprayPaint	20 pcs	11/28/18	11/28/18	0.00	0.92	Spray Paint		AS 19-2-5
225	Outsource	20 pcs	11/28/18	11/28/18			ATE003-VC	5	NR
230	QC	20 pcs	11/28/18	11/28/18	0.00	0.00	QC14		DAD 19.02.13
240	Packaging	20 pcs	11/28/18	11/28/18	0.00	0.00	Packaging3-1		6 FEB 15 2019
250	QC21-SA	20 Ea	11/28/18	11/28/18	0.00	0.00	QC21		9-89 DAS

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg
Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH
160 - Weld tube to plate as per dwg. DT9867
220 - Prime as per dwg (see note 3) 5147812
240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5560 sf (.0278 ea)	110-Waterjet - Flow - 1	
M304TR0.500W.049	304 Round Tube .500 X .049W	16.6600 ft (.833 ea)	140-Small Fab	5126572

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	197	0
140-Small Fab	M304TR0.500W.049	17	124	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			2.720
2	Strut	1.500Inches $\pm$ 0.030	1.530 1.470
3	Strut	0.063Inches $\pm$ 0.010	0.073 0.053

Plex 11/13/18 10:35 AM Dart.lajeunesse.marie



Container No: S127662



Part: 646.3511

Job No: 186244

Serial No/Batch: S127662

Revision:

Inspector:

Exp Date:

Instructions:

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					